| | esday, 3/11/2008 7:57:28 AM m Johnston | | | Split | |
|---|---|--|--|---|--------------|
| Cost, Kil | T COMPANY | Proce | ss Sheet | 2/11 | |
| Customer Job Number Estimate Number P.O. Number This Issue Prsht Rev. First Issue Previous Run Written By Checked & Appro Comment Additional Produ | : 3/11/2008 S.O. No. : : NC : // Type : M : 36747 oved By : Est D 00/1.01 A powder coat EC | ACHINED PARTS 3 03 11 dded inspection level 8, and | Part Number Drawing Number Project Number Drawing Revision Material Due Date | : MOUNTING LUG : D22301 : D2230 REV F : N/A : F : : 3/31/2008 Qty: | 200 Um: Each |
| Job Number: | | 1 | | | |
| Seq. #: | Machine Or Operation: | | Description : | | |
| 1.0 | D2423 | Lug Extrus | ion | | |
| | ment: Qty.: 0.0717 f(s)/Unit Lug Extrusion D2423 Extrus Batch: 833310 | Total: 7.1715 f(s) sion CL | 8/03/12 | (1.1715) | |
| 20 | BAND SAW | E issue ? | | | |
| Comr | Cut D2423 extrusion to 0.82 | t issue? | dug. | CZ08/03112 | 200) |
| 3.0 | HAKS1 | HAAS CNC | VERTICAL MACHINING | 6 #1 | |
| | nent: HAAS CNC VERTICAL MAG 1-Machine per folio D2230-1 (Check for crack while leading 2-Tumble and debut rough) | ng into the machine.) edges after tumbling | | emuge & S | 13/2 (100) |
| 4.0 | QC2 | | PARTS AS THEY COME | OFF MACHINE | |
| 50 | nent: INSPECT PARTS AS THEY | SECOND O | CHECK | | |
| | ment: SECOND CHECK | 1/202 | 24 120 | 100 - 27 80 | |
| | | COUNTR | (60) | peded pe cx-Po | |

| Dart Ae | rospace | Ltd | | | | | | | | |
|-------------|------------|-------------------|----------------------|-------------------|---------------|-------------|------------|-----------------------------|-------------------------------------|--------------------------|
| W/O: | | | W | ORK ORDER CH | ANGES | | | | | |
| DATE | STEP | PRO | OCEDURE CHA | NGE | WEAR THAT THE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | | | |
| | | | - Ąī | | 22. | | | | | 3 |
| Part No | : | PAR #: | Fault Cate | gory: | NCI | R: Yes | No DQA: | | _ Date: _ | |
| | | | | | | QA: N | /C Closed: | | _ Date: _ | |
| NCR: | | | WORK ORD | ER NON-CONF | ORMANCE | (NCR |) | | | |
| Clean and a | annually 4 | Description of NC | | Corrective Action | Section B | 1 - 1 | Verifica | fion | Approval | Approval |
| DATE | STEP | Section A | Initial Chief Eng | Action Descri | | Sign & Date | Section | ALCOHOLD THE REAL PROPERTY. | Chief Eng | QC Inspector |
| | | | | | A Second | | | | | |

| | - was a state of | Description of NC | | Corrective Action Section B | | | Approval | Annroval |
|--------|------------------|-------------------|----------------------|--|-------------|---------------------------|-----------|--------------------------|
| DATE S | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Verification Section C | Chief Eng | Approval QC Inspector |
| 9- | | | | | | | | |
| | | | | | | | | |
| | | | | | | ar i Subsection | | |
| 30 | | | | | 7.307 | | | |
| 4 | | | | | St. pel | | | |
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| 1 | | | | | 1- | | | |
| | | | | | - | 100 | | |
| | | | | PARTIE AND A STATE OF THE PARTIES AND ADDRESS OF | 1.40× 5.40 | | | |
| | | | | District Control of the Control of t | | | | |
| | | | | The second secon | | | it - | |
| | | | | | | 7- 124 | | |

NOTE: Date & initial all entries

| User: Kim | Johnston | Process Sheet | |
|---------------|--|--|---|
| Customer: | CU-DAR001 Dart Helicopters Service | Drawing Name: MOUNTING | GLUG |
| | | | |
| Job Number: | 3/745 | Part Number: D22301 | |
| Job Number: | | | |
| _ رينوارو | | | |
| Seq. #: | Machine Or Operation: | Description : | |
| 6.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 | 111111111111111111111111111111111111111 |
| | - IIII III III III II - 3 | Tubble por soy. 3.0 | |
| Comme | nt: HAND FINISHING RESOURCE | | 1-1 |
| | Acid etch and Alodine as per Q | The second secon | 3/24 (120) |
| 7.0 | QC5 | INSPECT WORK TO CURRENT STEP | |
| | | | caentes |
| Comme | nt: INSPECT WORK TO CURREN | T STEP & 08/03 | 1 |
| 8.0 | POWDER COATING | POWDER COATING | 15 |
| | | M107005 | (120X) |
| | | 1107000 | |
| Comme | nt: POWDER COATING Powder Coat Gloss White (ref. | 13.5.1) per Dart OSI 005.4.3 | 1 128/12/26 |
| 9.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CON | VERSION - |
| | | | 60 |
| | | | 1 Maria |
| | nt: INSPECT POWDER COAT | | \$ 08/05/26 |
| 10.0 | PACKAGING 1 | PACKAGING RESOURCE #1 | |
| | | | |
| Comme | nt: PACKAGING RESOURCE #1 | 2 | |
| | Identify and Stock | 1 to Com | Ti. |
| 11.0 | Location: | 93/26 (12°0) PINAL INSPECTION/WO RELEASE |) |
| 11.0 | 111111111111111111111111111111111111111 | 7 FINAL INSPECTION WO RELEASE | |
| | | | 125 |
| Comme | nt: FINAL INSPECTION/W/O RELI | EASE | 1208/03/27 |
| ob Completion | | | 2 27 |
| - 1 | | me | 08-03-27 |
| 100 | | | |
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Form: mrocess

Page 2

| Dart Ae | rospace | Ltd | | | | | | | |
|---------|-----------------------|--------------------|----------------------|------------------------------|-------------|---------|--------|-------------------------------------|--------------------------|
| W/O: | | WORK ORDER CHANGES | | | | | | | |
| DATE | STEP | PR | OCEDURE CHA | NGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| Part No | : | PAR #: | Fault Cate | gory: N | | | | _ Date: _ | |
| NCR: | | | WORK ORDI | ER NON-CONFORMANO | | | - | | |
| | 71 | Description of NC | | Corrective Action Section B | | Verific | action | Annousel | Annessal |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Secti | | Approval Chief Eng | Approval QC Inspector |
| | Control of the second | | | | | | ì | | |
| | 10 mm | | | | | | | | |

NOTE: Date & initial all entries

| DART AEROSPACE LTD | Work Order: | 37745 |
|------------------------------|--------------|-------------|
| | | |
| Description: Mounting Lug | Part Number: | D2230-1 |
| | | |
| Inspection Dwg: D2230 Rev: F | | Page 1 of 1 |

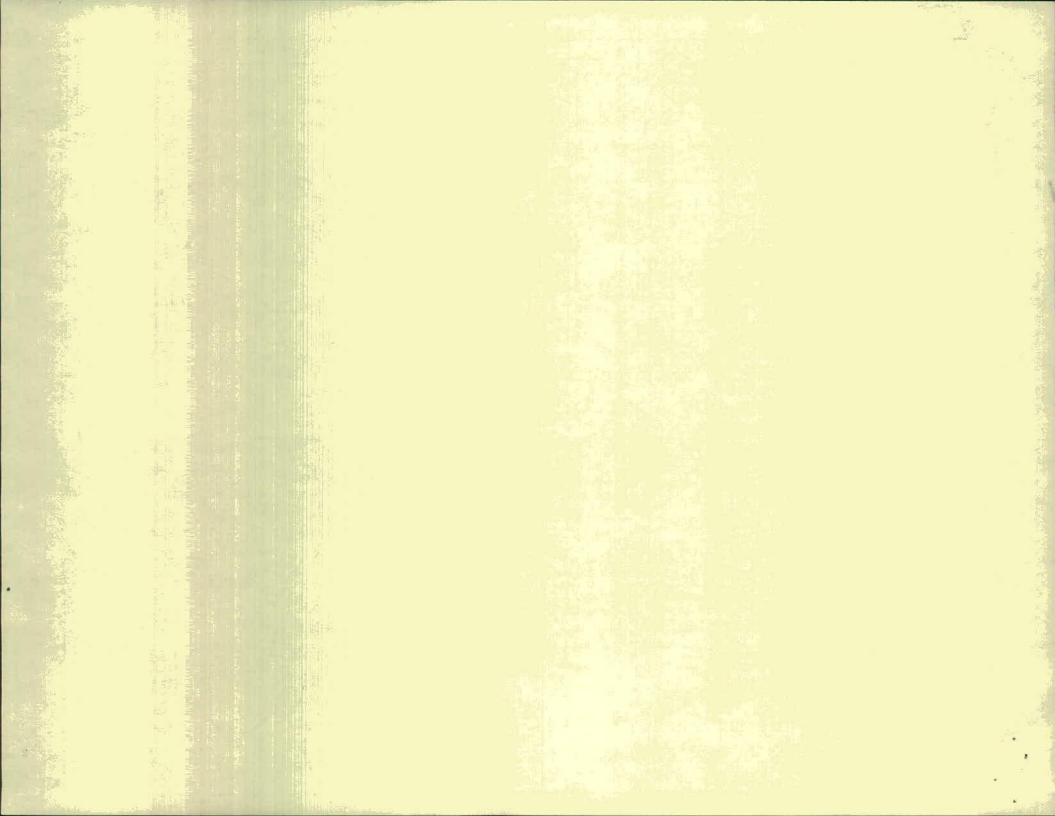
FIRST ARTICLE INSPECTION CHECKLIST

| X | First Article | P | rototype |
|---|---------------|---|----------|
|---|---------------|---|----------|

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|----------------------|---------------|---------------------|--------|--------|-------------------------|---------------|
| 4.450 | +/-0.010 | | | | | |
| 0.306 | +/-0.010 | | | | | |
| 0.345 | +/-0.010 | | | | | |
| 0.400 | +/-0.010 | | | | | |
| 0.250 | +/-0.010 | | | | | |
| 3.700 | +/-0.010 | | | | | |
| 0.750 | +/-0.010 | | | | | |
| Ø0.257 | +0.005/-0.000 | | | | | |
| 1.91 | +/-0.010 | | | | | |
| R1.200 | +/-0.010 | | | | | |
| 0.375 | +/-0.010 | | | | | |
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| Measured by: | Audited by: | Prototype Approval: | N/A |
|--------------|-------------|---------------------|-----|
| Date: | Date: | Date: | |

| | ate Change | 1,01,000 51 | Approved |
|--------|----------------|------------------|----------|
| A 03.1 | 1.11 New Issue | Revised by KJ/RF | 14 |





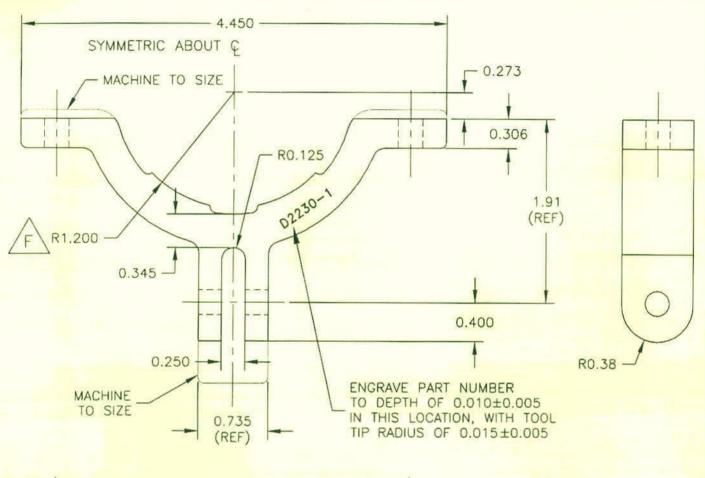


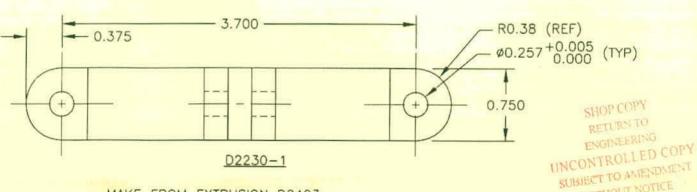
| DESIGN | P DRAWN BY | DART AEROS HAWKESBURY, ONT. | |
|---------|------------|--------------------------------|------------------------|
| CHECKED | APPROVED | DRAWING NO. D2230 | REV. F SHEET 1 OF 2 |
| DATE | | TITLE | SCALE |
| 99.12.1 | 13 | MOUNTING LUG | 1:1 |
| С | 94.03.30 | RE-DESIGN | |
| D | 95.01.04 | RE-DESIGN | |
| Ε | 95.01.04 | RE-DESIGN | |

| _ | 251050 - 77 | | | Malda and the little see the see | | | | 1.01 |
|---|-------------|----|---------|----------------------------------|--------|-----|--------|------|
| | С | 9 | 4.03.30 | RE-DESIGN | | | | |
| Ì | D | 9: | 5.01.04 | RE-DESIGN | | | | |
| į | Ε | 9: | 5.01.04 | RE-DESIGN | | | | |
| | F | 99 | 9.12.13 | REDESIGN; | R1.200 | WAS | R1.100 | |

WITHOUT NOTICE

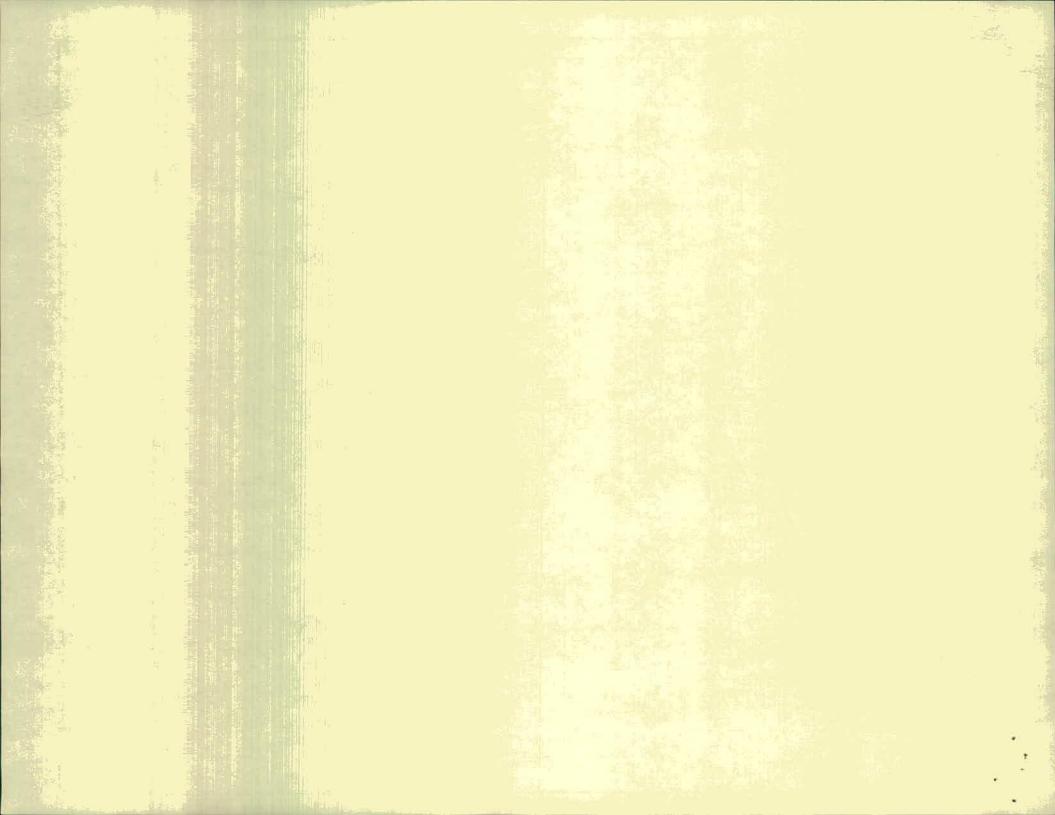
NO. 3





MAKE FROM EXTRUSION D2423 BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

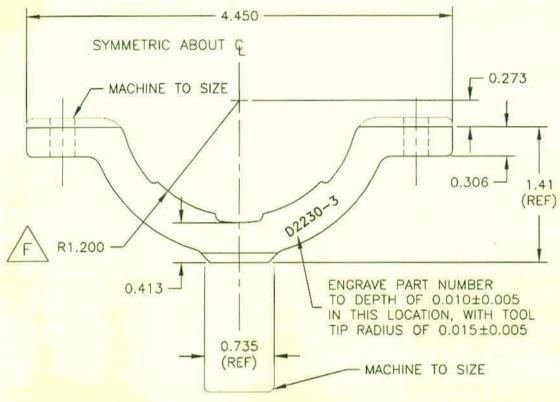


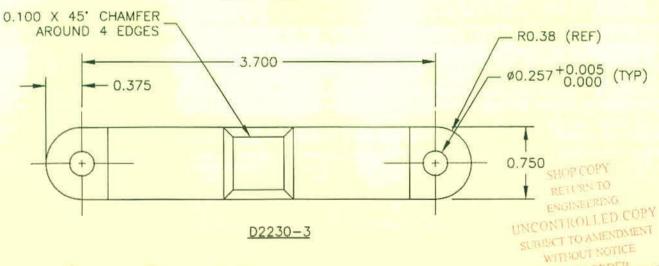




| DESIGN | P DRAWN BY | 1. E & O. C. | AEROSPACE | |
|----------|------------|--|-----------|------------------------|
| CHECKED | APPROYED | D2230 | | REV. F SHEET 2 OF 2 |
| DATE | - | TITLE | | SCALE |
| 99.12.13 | 5 | MOUNTING LUG | | 1:1 |

RELEASED





MAKE FROM EXTRUSION D2423 BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3,5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED





CERTIFICATE OF CONFORMITY

SOLD TO:

SHIPPED TO:

Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ont. K6A 1K7

same

QUANTITY

120

PART NUMBER

D2230-1

PART NAME

Mounting Lug

P.O. NUMBER

5896

MATERIAL: supplied by DART D2423 B33310

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Denise Robinson

Vankleek Hill, March 20, 2008

